

Work Order ID 68004

Tuesday, April 05, 2011 10:50:36 AM



Page 1

Item ID: D4380-33

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cover, Post Power Panel

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 2.00



Customer:

PRELIMINARY ISSUE *JA*

Reference:

Run Start

Approvals: Process Plan: *MF*Date: *11-04-05* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

D4380

PA6 PA7 06 11/04/05 AD

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

*Q**BB*
11/04/05

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 Kydex

Temp: *150°F*Time IN: *6:00 pm*Time OUT: *7:00 am**Q**BB*
11/04/05

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

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Start Date: 4/5/2011 Start Qty: 2.00

Required Date: 4/5/2011 Req'd Qty: 2.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA126 using tool DT9751

Dwg Rev: PA7Folio Rev: A.

2

BB
11/04/05

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

2

BB
11/04/05

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2

Wh.
11/04/05

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140



HandThermo

Memo

0.00

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

Dh.
11/04/05

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Complete FAI document

0.00

0.00

2

Dh.
11/04/05

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

- inspector to PAZ
Dwg only
8/16/06 (x2)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:50:33 AM

Page 1

Work Order ID: 68004



Parent Item: D4380-33



Parent Item Name: Cover, Post Power Panel

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Rev. A New Issue 11/04/04 DL verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MKYD6185S.080-P3- 62015 | | Purchased | No | | | 100 | sf | 787.2912 | 3.46875 | 6.9375 | | | |



6185 KYDEX .080"

Location

therm

116576

Loc Qty

787.2912

787.2912

Loc Code

6.9375 sq ft

DL
2/04/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|--|------------------------------|
| DART AEROSPACE LTD | Work Order: 68004 |
| Description: Post Power Panel cover | Part Number: D4380-33 |
| Inspection Dwg: D4380 Rev: PA7 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than <u>1/4</u> " | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

| | |
|--------------------------------|------------------------------|
| Measured by: <u>Whe</u> | Date: <u>11/04/05</u> |
|--------------------------------|------------------------------|

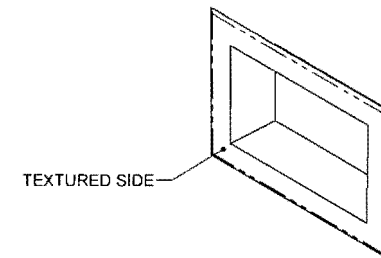
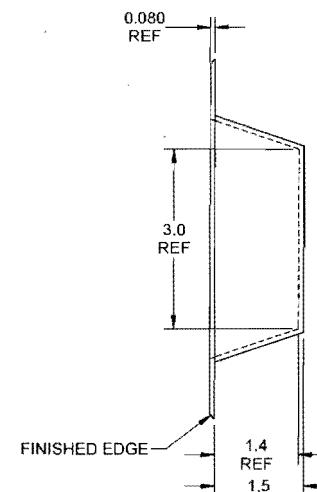
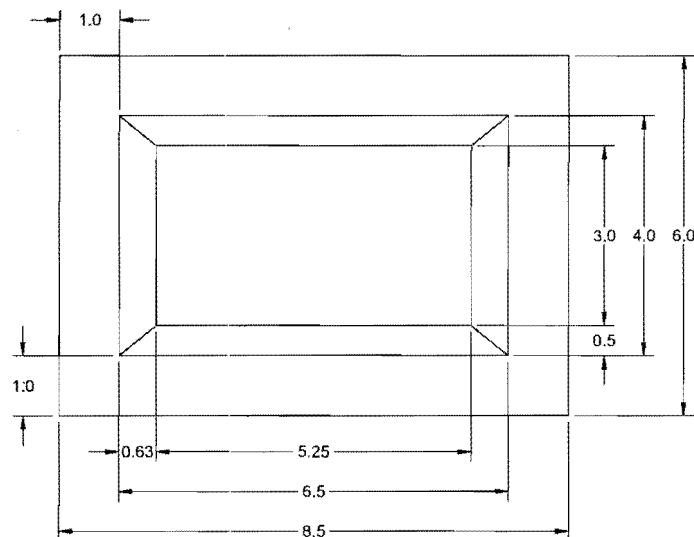
TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 8.5 | ± 0.100 | 8.4" | ✓ | | Tm TH-05 | |
| 6.5 | ± 0.100 | 6.5" | ✓ | | " | |
| 5.25 | ± 0.030 | 5.25" | ✓ | | vern TH-05 | |
| 6.0 | ± 0.100 | 6.0" | ✓ | | " " | |
| 4.0 | ± 0.100 | 4.0" | ✓ | | " " | |
| 3.0 | ± 0.100 | 4.9" | ✓ | | " " | |
| 1.0 | ± 0.00 | 1.0" | ✓ | | " " | |
| 1.4 | ± 0.100 | 1.46" | ✓ | | " " | |
| | | | | | | |
| | | | | | | |
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|--|------------------------------|
| Measured by: <u>Whe</u> | Date: <u>11/04/05</u> |
| Audited by: <u>D PA7 Dug only</u> | Date: <u>11/04/05</u> |
| Preliminary Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10.04.14



D4380-33 COVER, POST POWER PANEL

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -33 PART PER MOULD DT9751.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE

DL 11.04.05

| | | | |
|------------|-----------|---|----------------|
| DESIGN | <i>DL</i> | DART AEROSPACE LTD | |
| DRAWN | <i>DL</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. PA7 |
| MFG. APPR. | | D4380 | SHEET 17 OF 19 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CEILING POCKETS | NTS |
| DATE | 11.04.05 | <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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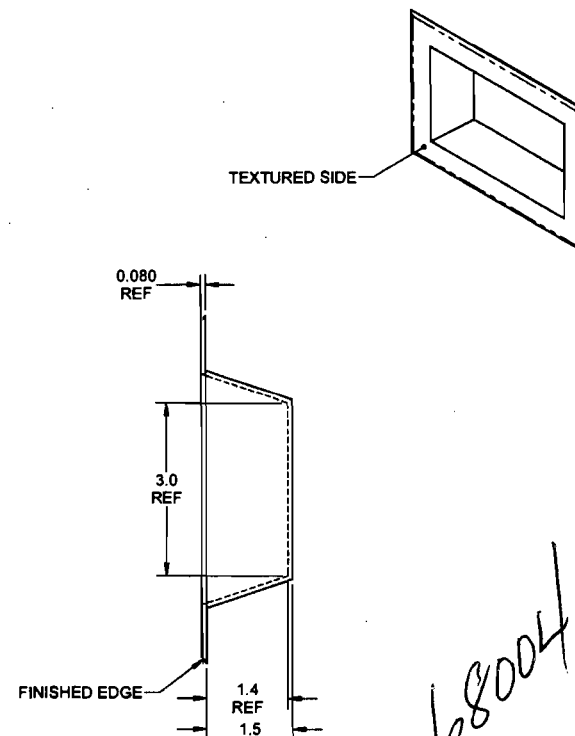
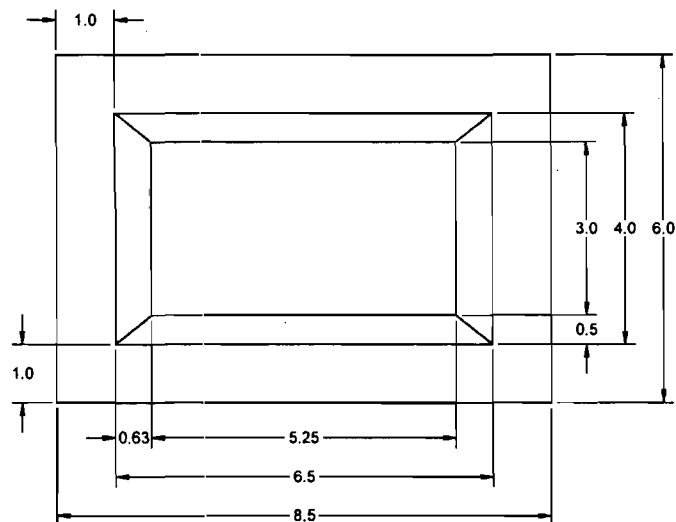
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REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.27 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9751 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE
- 11) MAXIMUM INSIDE RADIUS = 0.188

| | | | |
|---|----------|--|----------------|
| DESIGN | DC | DART AEROSPACE LTD | |
| DRAWN | DC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DC | DRAWING NO. | REV. A |
| MFG. APPR. | DC | D4380 | SHEET 17 OF 19 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | CEILING POCKETS | NTS |
| DATE | 11.04.21 | COPYRIGHT © 2011 BY DART AEROSPACE LTD | |
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RELEASED
2011-05-19
JND

